

Work Order ID 63621

Page 1

Friday, November 05, 2010 10:21:52 AM

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Item Name: Aft Upper Rib Assembly

Stop



Start Date: 11/5/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/16/05 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4034

A

100

Weld per dwg A/R S.S. rod Batch: 111585

0.00

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

(P) 10.12.07

(3x)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(BE)
10.12.07

3 *f*

120

QC5- Inspect part completeness to step on W/O

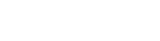
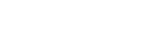
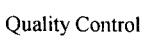
0.00

QC

Memo

0.00

Quality Control



8.01.12.07

(X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Batched 400
Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/12/08 (3x)
11/12/10
11/12/10

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Picklist Print

Friday, November 05, 2010 10:21:57 AM

Page 1

Work Order ID: 63621



Parent Item: D4034-041



Parent Item Name: Aft Upper Rib Assembly

Start Date: 11/5/2010

Required Date: 11/12/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4034-1

 Rib
 Manufactured No 100 Each 0.0000 1 3 ② *B64169→①*
363116 Cpl 10.12.01

D4034-3

 Rib
 Manufactured No 100 Each 0.0000 1 3 ② *B64168→①*
363117 Cpl 10.12.01 B641620→①

D4021-7

 Hoop
 Manufactured No 100 Each 7.0000 1 3 *Cpl 10.12.01*
B64260
364620→①

D4021-9

 Bushing
 Manufactured No Location WA Loc Qty Loc Code
 58039 7
 63115 1
 6
 22.0000 2 *Cpl 10.12.01*
⑤
6

Location WA Loc Qty Loc Code
 56094 2
 60184 4
 60803 16
④⑥

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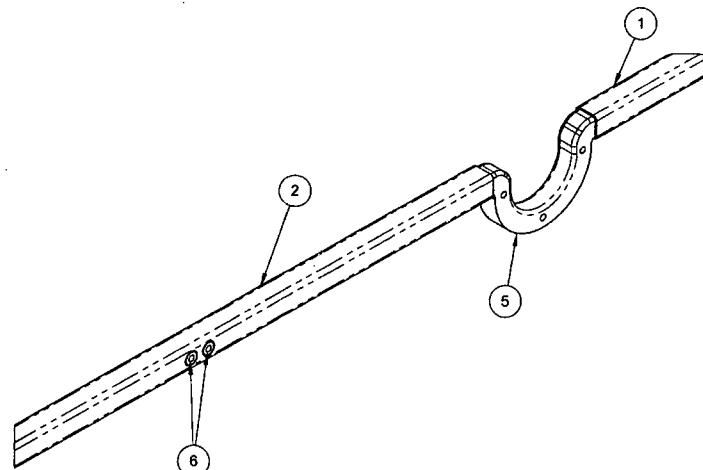
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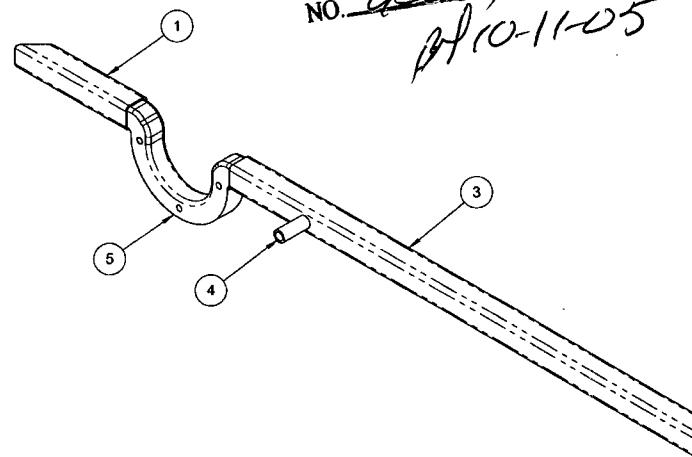
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43627*
09/10-11-05



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
MW

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GD</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>EZ</i>	D4034	SHEET 1 OF 4
APPROVED	<i>ND</i>	TITLE	SCALE
DE APPR.	<i>ND</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

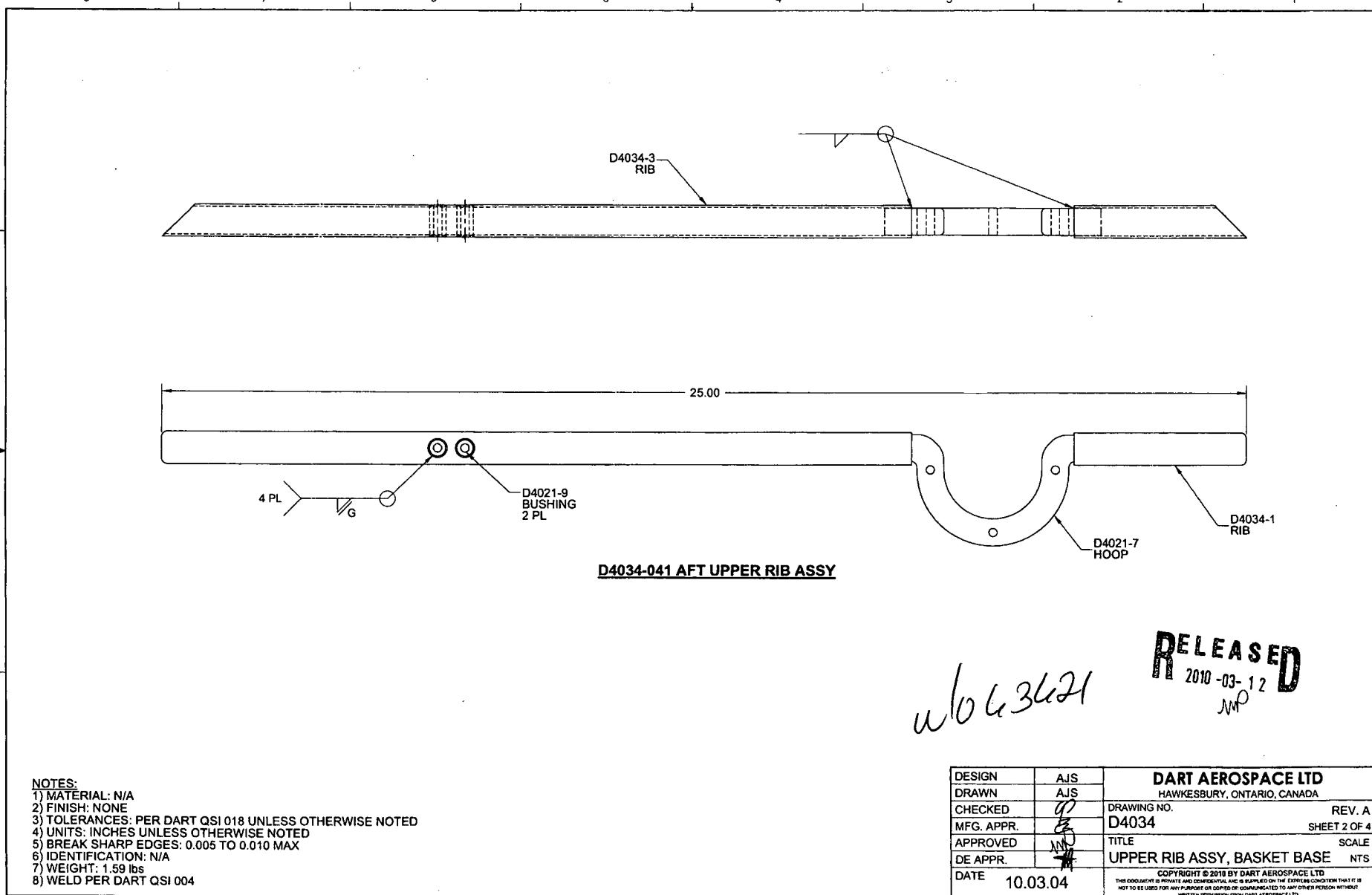
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8 7 6 5 4 3 2 1

A

A

D

D

C

C

B

B

A

A

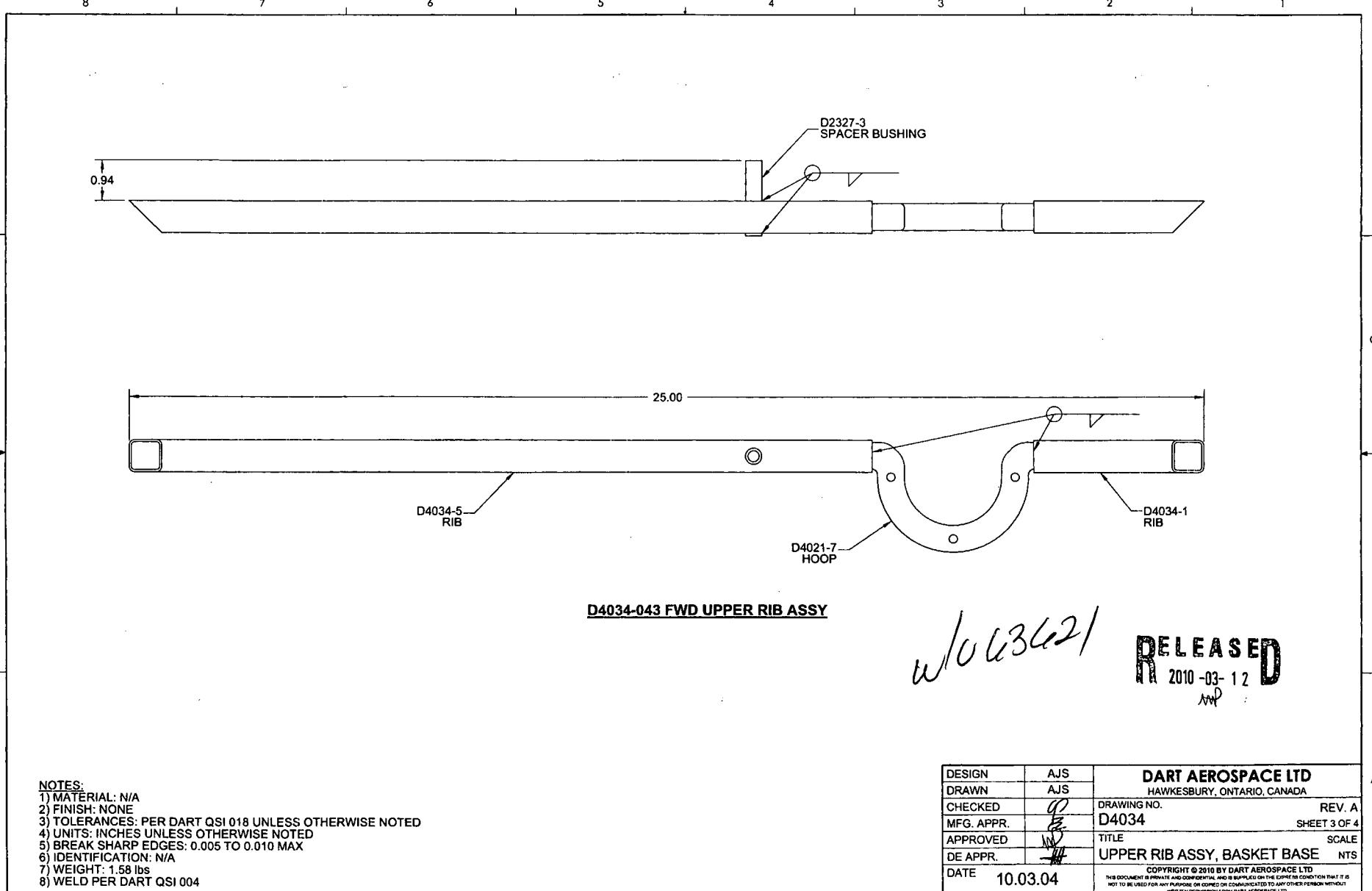
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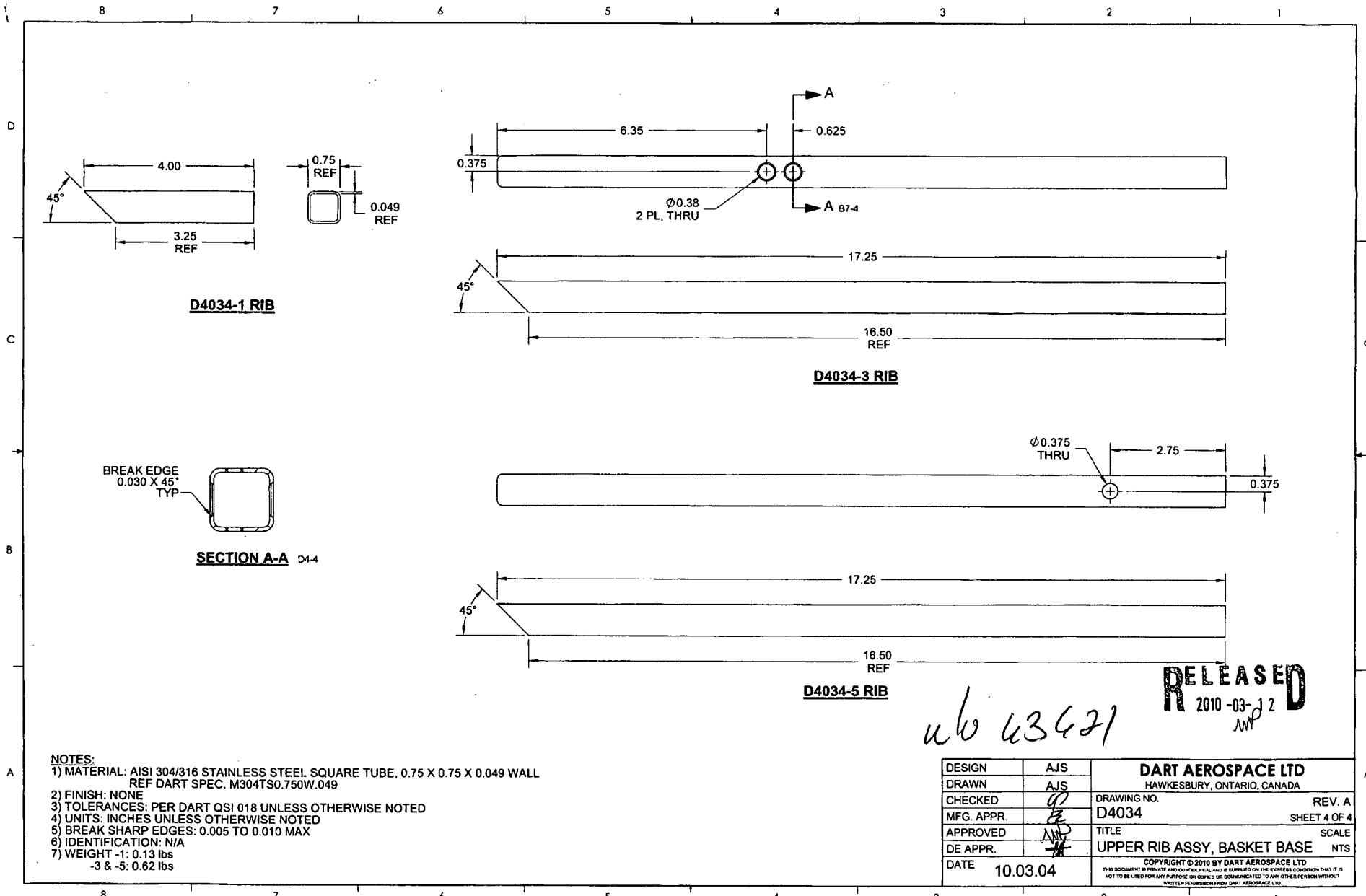
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